



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5501-3
Job Sheet 196942



Part No: D5501-3

Job Qty: 4 pcs

Part Name: Body, Lower Cutter, Short



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/19

Job Tracking No:

Created By: Kimberley Guerin

Due Date: 7/5/19

Type: SOLD

Description:

Note: D5501 REV:A7 IPP rev:a RQ 17.08.17 Verified by: DD IPP REV:B 18.01.22 AS PER DWG REV:A7 DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	4 pcs	7/5/19	7/5/19	0.00	0.20	Bandsaw - 1	DJP 19-07-09
110	HAAS 4 Axis - B4B	4 pcs	7/5/19	7/5/19	1.00	18.98	HAAS - 1 - B4B	DJP 19-07-09
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	4 pcs	7/5/19	7/5/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	



Container No: S196733



Part: D5501-3

Job No: 196942

Serial No/Batch: S196733

Revision: A7

Inspector:

Exp Date:

Instructions:

Date: 07/09/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	DP 19-07-09
					QC 2 - 69	
130	QC 8	4 pcs	7/5/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	UHT 19/7/10
					QC 8 - 57	
140	Outsource - 4 - Anodize	4 pcs	7/5/19		ATG001-VC	10 KH 2019-07-11
150	Packaging 2-1 - Receive - B4B	4 pcs	7/5/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DP JUL 17 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	

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				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
155	QC 5	4 pcs	7/5/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
180	Packaging 3-1 - Stock - B4B	4 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B

DAS
61
9-89

PC SCK128

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	4 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut Blank at 5.00"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per Folio FB558 + Dwg. D5501 DWG REV: _____ FOLIO

REV: _____ 2- deburr and break all sharp edges

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG: 43977 HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** As Per Dwg D5501 Rev. A7 Certification of Conformity is required

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.250X10.000	7075-T6S Sheet 1.250" Thick X 10.000" Wide	1.6664 ft (.4166 ea)	100-Bandsaw - 1	M/38202

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.250X10.000	2	9	0

Part Specifications	
Specifications could not be found.	

MAT
used
1.683'
+0.421'
2.104'

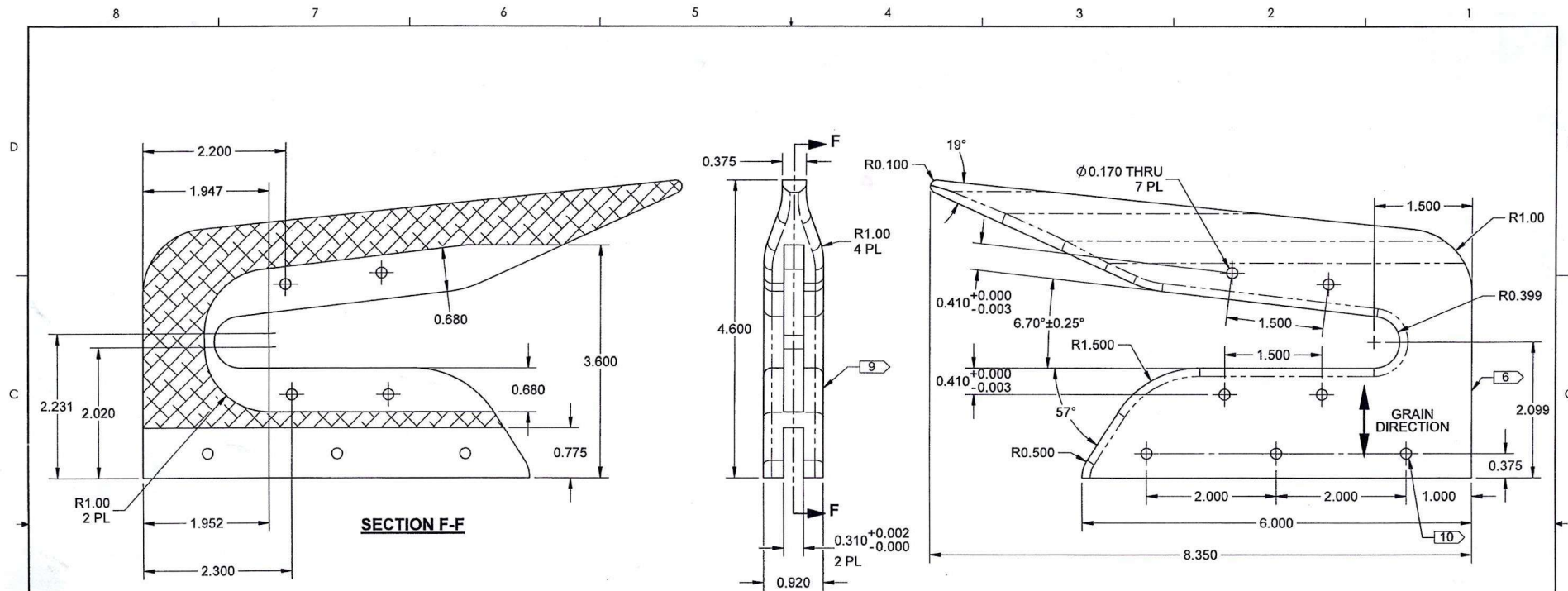
(F_m 138202.0)

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1.683 Used
÷ 4 pieces
(0.42075 ea)

1.683 + 0.421
2.104 ft. Used
5 pcs

2.104' used
2.083' Bom
0.021' Scrap



D5501-3 BODY, LOWER CUTTER, SHORT

NOTES:

- 1) MATERIAL: 7075-T6/T62/T651 ALUMINUM PLATE
PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS 4045 OR ASTM B209
REF. DART SPEC M7075T6S
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-PRF-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5501-3", TAI P/N "RC95T402200VN", DWG REVISION
BATCH NUMBER AND MANUFACTURE DATE PER QSI 044 METHOD 6.2
- 7) WEIGHT: 1.33 lbs (0.60 kgs)
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILE D5501-3A.STEP
- 9) RADIUS OUTSIDE EDGE TO 0.125
- 10) PILOT DRILL ONLY. REAM TO FINAL SIZE AFTER FINISHING. TOUCH UP BARE METAL WITH
ELECTRICALLY CONDUCTIVE CHEMICAL FILM MATERIAL (ALODINE 600) PER MIL-DTL-5541

RELEASED

2019 JUN 11

APPROVED

DESIGN	JMH	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. A
MFG. APPR.	RQ	D5501	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	N/A	LOWER CUTTER ASSEMBLY	NTS
DATE	18.06.29	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 196942
Description: BODY LOWER CUTTER, SHORT		Part Number: D5501-3
Inspection Dwg: 5501 Rev: A		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.200	(±) .01	2.199	✓		Ver	
2.300	(±) .01	2.299	✓		Ver	
0.680	(±) .01	0.675	✓		H.G.	
3.600	(±) .01	3.600	✓		Ver	
0.680	(±) .01	0.672	✓		H.G.	
0.775	(±) .01	0.776	✓		Ver	
0.375	(±) .01	0.375	✓		Ver	
4.600	(±) .01	4.600	✓		H.G.	
0.920	(±) .01	0.920	✓		Ver	
0.310	+0.002 -0.000	0.311	✓		G.P.	
R. 100	(±) .01	R. 100	✓		R.G.	
19°	(±) .5°	19°	✓		A.F.	
0.410	+0.00 -0.003	0.410	✓		Ver	
0.410	+0.00 -0.003	0.409	✓		H.G.	
6.7°	(±) .25°	6.7°	✓		A.F.	
1.500	(±) .01	1.500	✓		Ver	
1.500	(±) .01	1.499	✓		Ver	
1.500	(±) .01	1.502	✓		Ver/cal.	
R. 100	(±) .03	R. 100	✓		R.G.	
R. 0.399	(±) .01	R. 0.399	✓		calculated	
2.099	(±) .01	2.099	✓		"	
0.375	(±) .01	0.375	✓		Ver	
1.000	(±) .01	1.000	✓		Ver	
2.000	(±) .01	1.999	✓		Ver	
2.000	(±) .01	1.999	✓		Ver	
6.000	(±) .01	5.995	✓		Ver	
8.350	(±) .01	8.340	✓		H.G.	
R. 0.500	(±) .01	R. 0.500	✓		R.G.	
57°	(±) .5°	57°	✓		A.F.	
φ 0.170	-0.001 +0.005	φ .172	✓		G.P.	
	DAS					

Measured by: 52 9-89	Checked by: [Signature]	QC Inspector:
Date: 19/07/08	Date: 19/7/10	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043977



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043977

PO Date: 7/11/19

Due Date: 7/17/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ***RUSH***

E-MAILED
2019-07-17

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196942	D5501-3	Body, Lower Cutter, Short (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** As Per Dwg D5501 Rev. A7 Certification of Conformity is required	Firmed -		7/17/19	5 pcs	0 pcs	5 pcs	\$27.78/pcs	\$138.90
2	196944	D5502-3	Windshield Deflector - Lower Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P- 23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed -		7/17/19	4 pcs	0 pcs	4 pcs	\$27.78/pcs	\$111.12
Grand Total:											\$250.02



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043977



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/17/19 3:19 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918225

Date: 17-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
5 ea	Part: D5501-3 Body, Lower Cutter, Short Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25459 PO: POHB043977	Rev: A7	Line: 1
4 ea	Part: D5502-3 Windshield Deflector - Lower Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25460 PO: POHB043977	Rev:	Line: 2
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUL 17 2019</u> Certified Signature: <u></u> Receiver Signature: <u></u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

RECEIVED
JUL 17 2019
DART AEROSPACE LTD.